

Date: Wednesday, 07/01/2009 1:36:50 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 155 BRACKET
 Job Number : 44475
 Estimate Number : 11039
 P.O. Number :
 This Issue : 07/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D28041
 Drawing Number : D2804 REV C
 Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : C
 Material :
 Previous Run : 41739 Due Date : 23/01/2009 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : JLD 09.01.09
 Comment : Est. A00.11.06 New Issue EC
 Est. B06.05.30 Blanks on wtjetEC
 Est Rev:C As per Rev C 06-11-09 JLM
 Est Rev:D Removed Tumbling 08-09-09 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X12000 6061-T6 Bar .500 x 12.00



Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 109253

IB 9-1-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: C

Prog Rev: C

IB 9-1-12

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

mmf 09/01/13

8

P70

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/01/13

8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2804-1 PAR #: N/A Fault Category: Prod/PAB ASS med & small NCR: Yes No DQA: D Date: 09/01/23
D2804-041/043 - D412-630-013/023/033/011
Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/01/23

NCR: <u>44475</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/23	3.0	Top .757" Hole is .764" R.C changed P.D. but forgot to change offset. Human error lack of attention. water set.	CP 09.01.13 PV 09/01/23	SCRAP PART. ENG IS UNABLE TO SUBSTANTIATE. DEVIATION ON HOLE AS PART WAS SUBST. BY TEST. and replace qty <u>(X)</u> B# <u>M109253</u>	mmf 09/01/23	inf 09/01/23	CP 09.01.23 09/01/23	S 09/01/23

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 1:36:50 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 44475

Part Number: D28041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 09/01/17

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

09-01-20

(XS)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 151A

JS

09/01/20 (XS)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/20 *JS*

Job Completion



U 09.01.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>14475</u>
Description: Bracket		Part Number: D2804-1
Inspection Dwg: D2804 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.010/-0.001	0.758	✓			
Ø0.191	+0.005/-0.001	0.190	✓			
1.420	+/-0.001	1.419	✓			
Ø0.507	+0.000/-0.001	0.506	✓			
0.250 deep	+/-0.010	0.249	✓			
Ø0.507	+0.000/-0.001	0.506	✓			
Ø0.191	+0.005/-0.000	0.191	✓			
6.933	+/-0.010	6.933	✓			
7.578	+/-0.010	7.577	✓			
12.304	+/-0.010	12.303	✓			
0.125	+/-0.010	0.127	✓			
0.500	+/-0.010	0.501	✓			
0.125	+/-0.010	0.125	✓			
0.250	+/-0.010	0.250	✓			
0.875	+0.000/-0.001	0.875	✓			
0.250	+0.000/-0.005	0.249	✓			

Measured by: <u>mmk</u>
Date: <u>09/01/13</u>

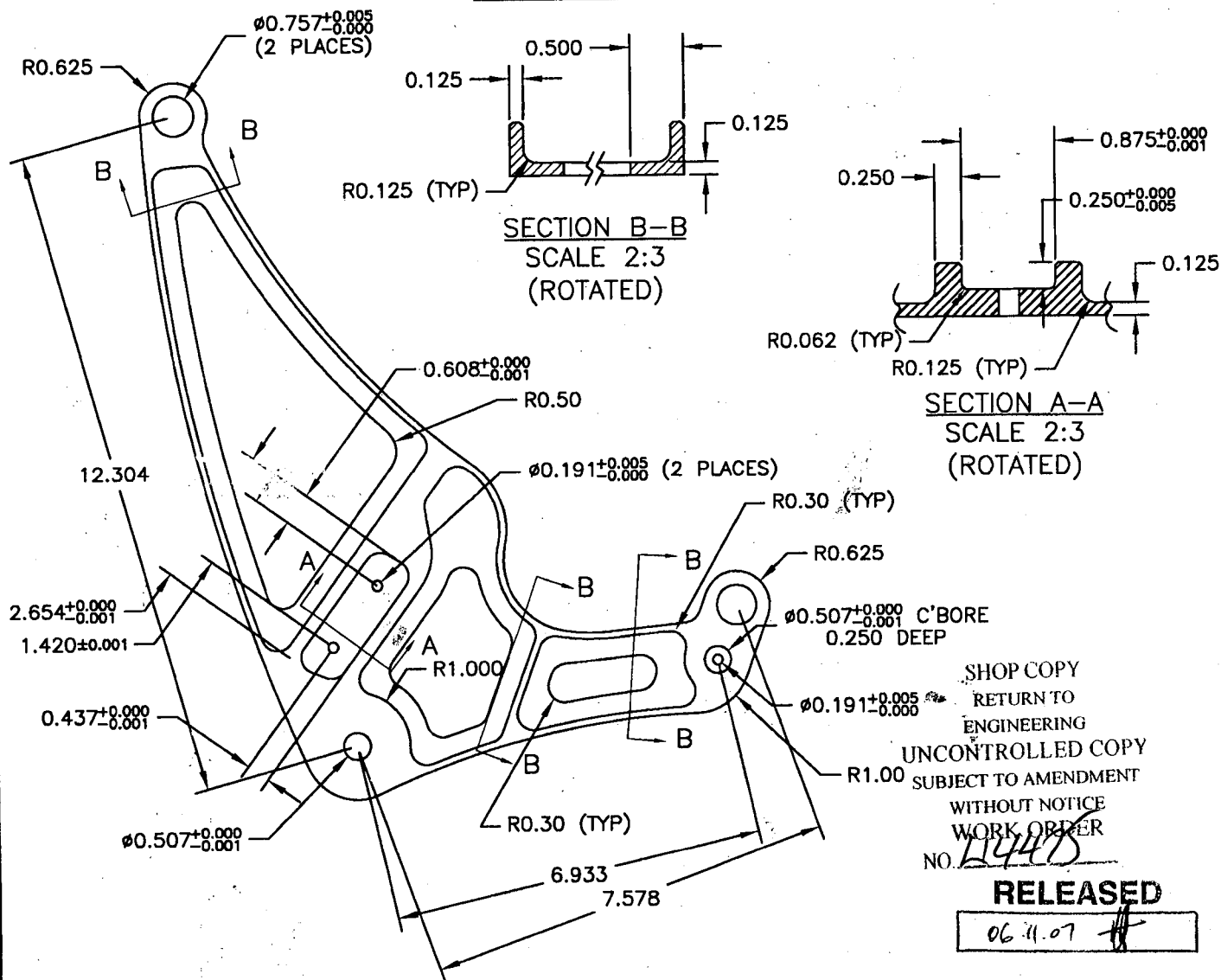
Audited by: <u>Smf</u>
Date: <u>09/01/12</u>

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	<u>BE</u>

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2804 REV. C SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

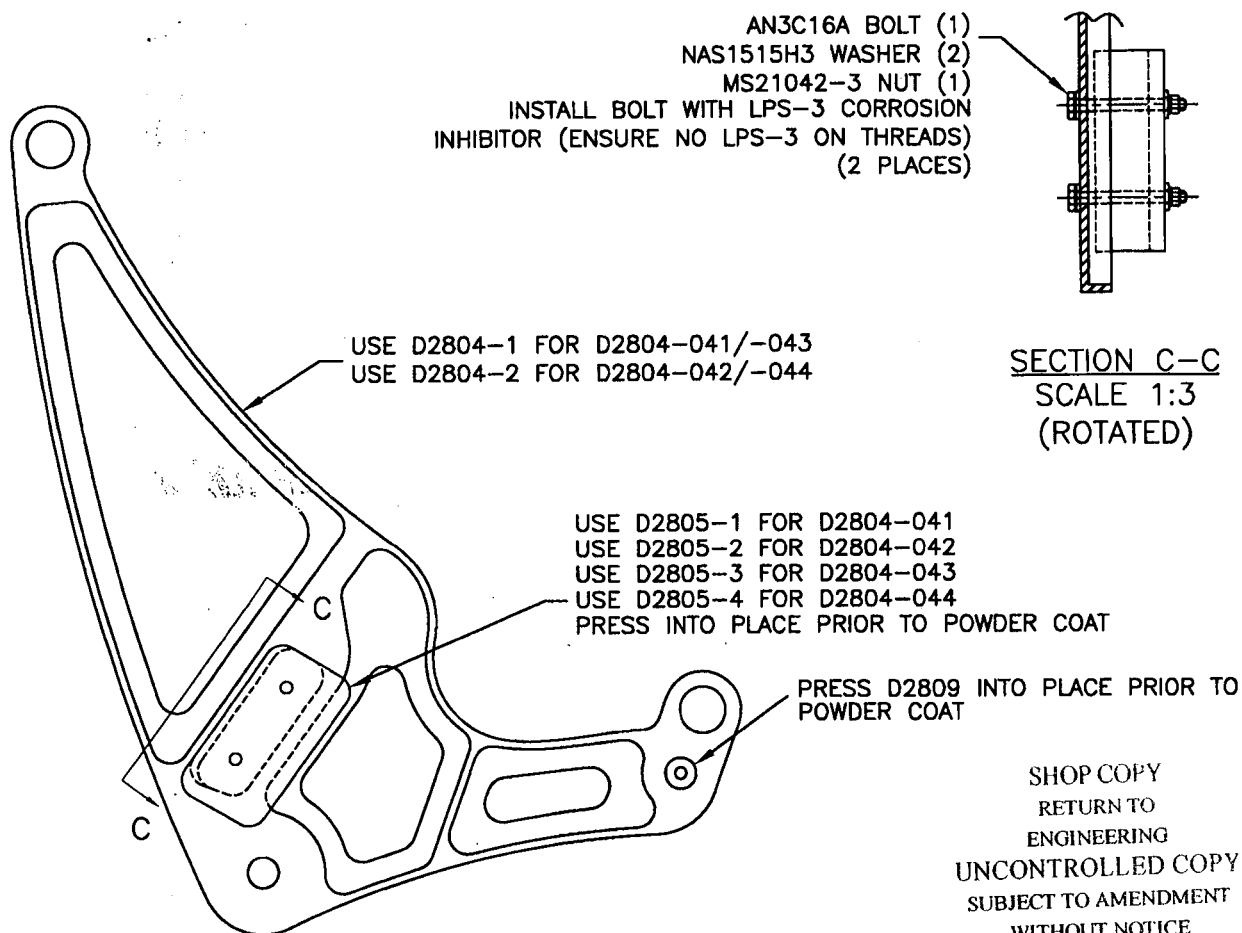
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44475

RELEASED

06.11.07 [Signature]

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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